



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3713-041
Job Sheet 178102



Part No: D3713-041

Job Qty: 1 ea

Part Name: Lid Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A new issue 08-01-30 DD verified by:EC IPP Rev:B change to revB ecn 1145 08-03-19
DD verified by:EC IPP Rev:C add label DD 10.03.23 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-6-11
100	Large Fab	1 pcs	6/15/18	6/15/18	0.00	16.67	Large Fab 8		D.M.L 18-6-11
110	Large Fab	1 pcs	6/15/18	6/15/18	0.00	16.67	Large Fab 1		18-6-11
120	QC	1 pcs	6/15/18	6/15/18	0.00	0.00	QC5		18-06-14
130	QC	1 pcs	6/15/18	6/15/18	0.00	0.00	QC9		18-06-19
140	Powdercoat	1 pcs	6/15/18	6/15/18	0.00	0.33	Powdercoat4		18-6-19
150	QC	1 pcs	6/15/18	6/15/18	0.00	0.00	QC3		18-6-19
160	HandFinish	1 pcs	6/15/18	6/15/18	0.00	2.27	HandFinish3		18-6-19
170	QC	1 pcs	6/15/18	6/15/18	0.00	0.00	QC3		18-6-25
180	Packaging	1 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-1		21 JUN 25 2018
190	QC21-SA	1 Ea	6/15/18	6/15/18	0.00	0.00	QC21		9-00

Part Op 100 - 1- drill holes in both D3715-1 as per dwg D3715 2- deburr 3- assemble as per dwg D3713 and weld as per QSI 005 4.4
Descriptions: 110 - 1- cut mesh as per dwg D3743 2- weld mesh as per dwg D3713
140 - START TIME: 8:45 FINISH TIME: 9:15.01:500. 1138700
160 - 1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4 2-Apply Clear coat over label on lid only
clear 138832 18 JUN 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2327-1	Spacer Bushing	2 Ea (2 ea)	90-Start up Operation	5061562
D2329	Label Plate	1 Ea (1 ea)	90-Start up Operation	102848
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5061216
D3749-1	Hinge Half	3 Ea (3 ea)	90-Start up Operation	506537(1x) 5075711
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	31.0220 ft (31.022 ea)	90-Start up Operation	5059803
M304EX0.75-16F	Expanded Metal Flat SS	.17 sf (17 ea)	110-Large Fab	5070544
D2258-300	Placard	1 Ea (1 ea)	160-HandFinish	5027158
M.U. 003583				003583

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2327-1	2	8	0
	D2329	1	4	0
	D2581	2	73	0
	D3749-1	3	4	0
	M304TS0.750W.065	31	1,059	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

110-Large Fab
160-HandFinish

M304EX0.75-16F
D2258-300

17
1

1,570
9

0
0

Part Specifications

Specifications could not be found.

Plex 5/28/18 7:24 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																		
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval																	
Master Unit 003583 Job No 178102 Container No: S079650 Part: D3713-041 Job No: 178102 Serial No/Batch: S079650 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K64 1K7 CANADA TEL: 1-813-832-5200 Email: sales@dartero.com www.dartaerospace.com Date: 06/11/18																				